

Work Order ID 78407

78407

January-09-12 8:58:01 AM

SHIP 19 JAN

Page 1

Item ID: D3913-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Base Assembly, 350
 Start Date: 09/01/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 23/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/09 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3913	A
D4020	A

100 Weld per dwg A/R S.S. rod Batch: M117834 0.00
 100 Large Fab

Memo 0.00

Large Fab
 1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

PL 12-01-17 1x Ø

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110 QC Memo 0.00

Quality Control

B.F.
 12-01-18

1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

8/12/01/15

Not M / 12/04/18

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat									
Powder Coating									

Memo 0.00
1- Plug holes and mask only interior of hinge (3) prior to powder coat

IST COAT: 3=20
START TIME: 400 OF
OVEN TEMPERATURE:
FINISH TIME: 2-50
***** 2nd coat if necessary *****
2ND COAT:
START TIME:
OVEN TEMPERATURE:
FINISH TIME:

Handwritten signature: NPM-12/01/18

140	QC3- Inspect Part Finish	0.00							
140									
QC									
Quality Control									

Memo 0.00

Handwritten signature: 1 BK 12-1-19

Handwritten: M119480

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150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	Pick Kit								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>NH032-011</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

SP 12-01-18

812/01/19

1 BL 12-1-19

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Revision ID:

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Start Date: 09/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

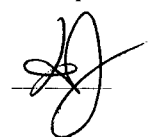
180

QC

Memo

0.00

Quality Control

12/1/19 

12-01-19

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Picklist Print

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Page 1

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

81.0000

2

2

D2581

Mounting Bracket

**

Pl 12.01.11

Location

Loc Qty

Loc Code

WA005

81

69739

1

70766

2

75280

1

77045

48

77523

29

2

D3913-1

Manufactured

No

100

Each

4.0000

1

1

D3913-1

Rib

**

Pl 12.01.11

Location

Loc Qty

Loc Code

WA006

4

74827

4

1

D3913-15

Manufactured

No

100

Each

3.0000

1

1

D3913-15

Wide Handle Plate

**

Pl 12.01.11

Location

Loc Qty

Loc Code

WA005

3

74640

3

1

W/O:		WORK ORDER CHANGES					
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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-3
D3913-3
Rib

Manufactured No

100 Each

4.0000

1 1

**

PL 12.01.11

Location

Loc Qty

Loc Code

WA006

4

69160

1

74904

3

Manufactured No

100 Each

0.0000

2 2

**

B75835 → ② PL 12.01.11

✓ D3913-7
D3913-7
Rib

✓ D3913-9
D3913-9
Hinge Rib

Manufactured No

100 Each

4.0000

1 1

**

PL 12.01.11

Location

Loc Qty

Loc Code

WA006

4

70138

1

74902

3

Manufactured No

100 Each

4.0000

2 2

**

PL 12.01.11

✓ D3916-041
D3916-041
Rib Assembly

Location

Loc Qty

Loc Code

WA

2

76333

2

WA006

2

69161

2

Manufactured No

100 Each

6.0000

3 3

**

PL 12.01.11

✓ D3916-5
D3916-5
Light Rib

Location

Loc Qty

Loc Code

WA006

6

75300

6

③

January-09-12 8:58:06 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 78407

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No

100 Each 22.0000 3 3

✓ ***D4016-1***

Hinge Half, Base

**

PL 12.01.11

Location Loc Qty Loc Code

WA005 22
74140 4
75281 18

③

D4017-7 Manufactured No

100 Each 2.0000 1 1

✓ ***D4017-7***

Rib

**

PL 12.01.11

Location Loc Qty Loc Code

WA005 2
69730 1
74638 1

①

D4017-9 Manufactured No

100 Each 12.0000 2 2

✓ ***D4017-9***

Rib

**

PL 12.01.11

Location Loc Qty Loc Code

WA006 12
70341 2
73531 4
76540 6

②

D4020-11 Manufactured No

100 Each 3.0000 2 2

✓ ***D4020-11***

End Mesh, Basket

**

PL 12.01.12
B77143 → ①

Location Loc Qty Loc Code

WA035 3
69648 2
74386 1

①

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Shop Packet Print

Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 78407

78407

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-1

Manufactured No

100 Each

12.0000

3

3

**

D4021-1

Handle Plate

Location

Loc Qty

Loc Code

WA005

12

74946

3

74986

9

100 Each

2.0000

1

1

**

D4034-041

Manufactured No

D4034-041

Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

2

76543

2

100 Each

2.0000

1

1

**

D4034-043

Manufactured No

D4034-043

Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

2

76541

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100 sf

499.2911 33 33

M304EX0 75-16F

Expanded Metal Flat SS

**

SP 12-01-11

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

499.2909803

117197

102.9036

117896

38.3264

118153

76.8473

118248

3.0983

118597

21.06788

118955

82.17

119180

64.537916

119729

110.339584

AN3-10A

Purchased

No

150 Each

131.0000 6 6

AN3-10A

Bolt

**

SP

Location

Loc Qty

Loc Code

GA

95

119084

95

ST351

36

117795

20

119128

16

AN960JD8

NAS1149DN832

Purchased

No

150 Each

0.0000 2 2

AN960.ID8

Washer

**

*m 119717
SP 12-01-18*

January-09-12 8:58:06 AM

Shop Packet Print

Page 5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2931

Manufactured No

150 Each

534.0000 2 2

D2931

Bumper

**

SP

Location

Loc Qty

Loc Code

ST504

534

46064

534

D4021-5

Manufactured No

150 Each

20.0000 2 2

D4021-5

Blanking Plate

**

2x

SP

Location

Loc Qty

Loc Code

GA

20

73478

20

MS20600-AD4W3

Purchased No

150 Each

1,025.000 2 2

MS20600-AD4W3

Cherry Rivets

**

2x

SP 12-d-18

Location

Loc Qty

Loc Code

ST321

892

111636

36

117505

111

117601

35

118626

710

WA018

133

107939

133

2x

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Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

6,189.000

6

6

MS21042L3

**

SP

Nut

Location

Loc Qty

Loc Code

ST300

6189

117441

16

117885

32

118451

5

118927

3

119017

5610

119075

523

6x

NAS1149F0332P

Purchased

No

150

Each

328.0000

12

12

NAS1149F0332P

**

SP 12-01-18

WASHER

Location

Loc Qty

Loc Code

ST275

328

117735

45

119225

280

17317

3

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

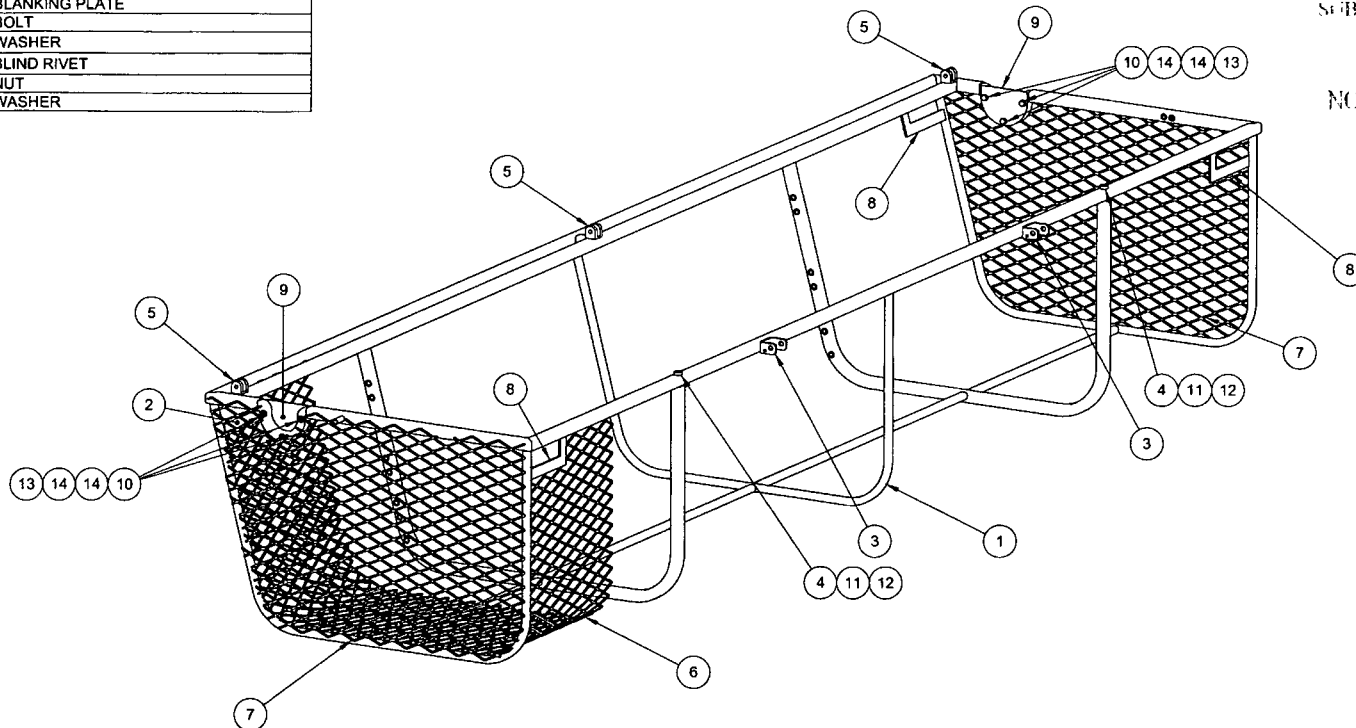
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ASSIGNMENT
WITH THE
WORK ORDER
NO. 78407 M.L.J
12/01/09

RELEASED
2010-03-22
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A
SHEET 1 OF 6
TITLE **LONG BASKET BASE ASSY (350)** NTS
SCALE

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W/O:		WORK ORDER CHANGES					
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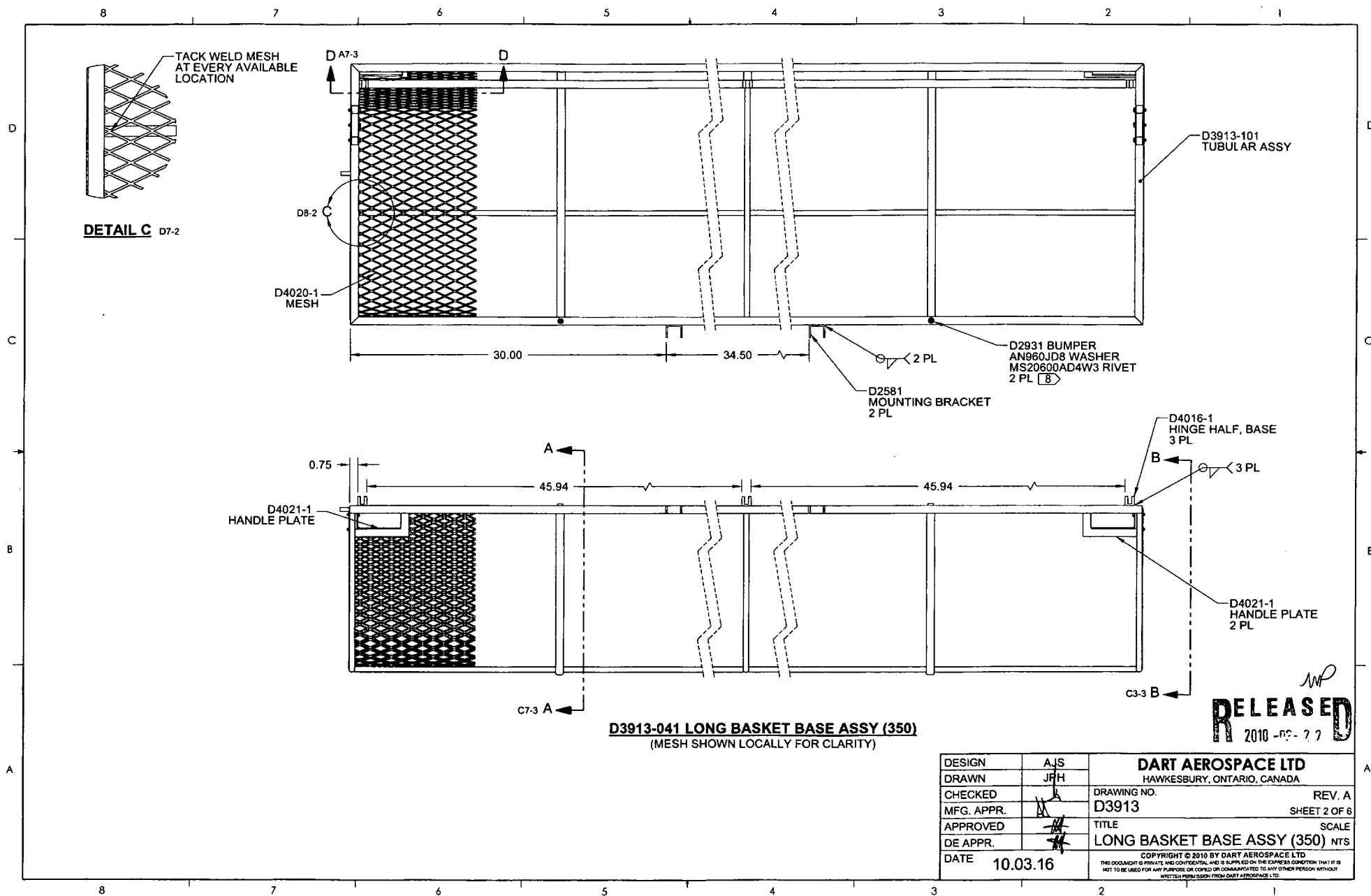
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78407



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2010-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

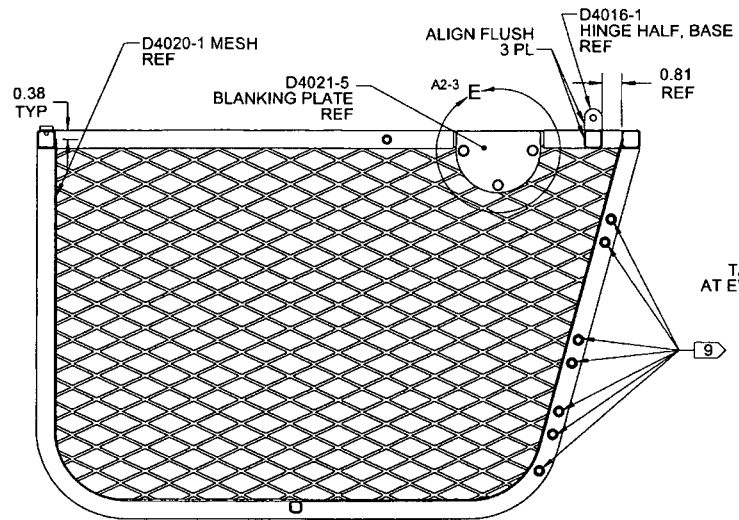
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

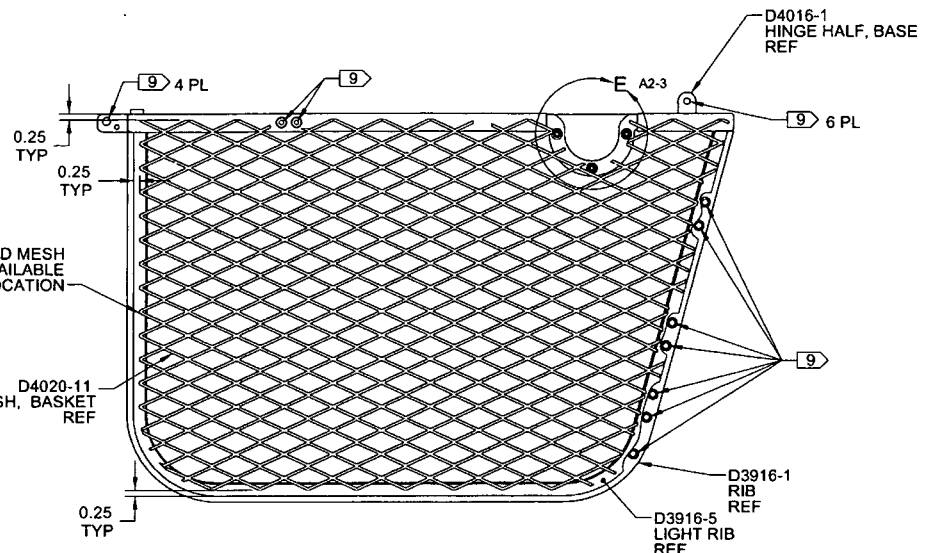
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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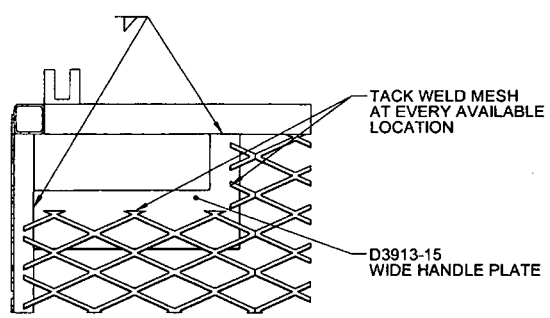
78407



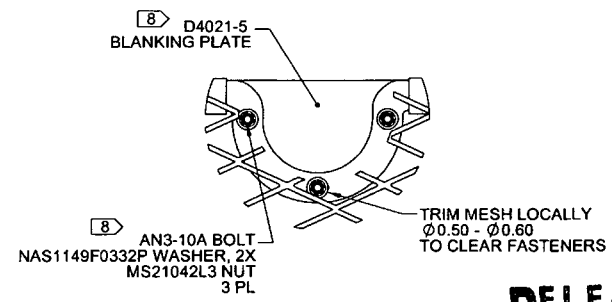
SECTION A-A A5-2



VIEW B-B A2-2







SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

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2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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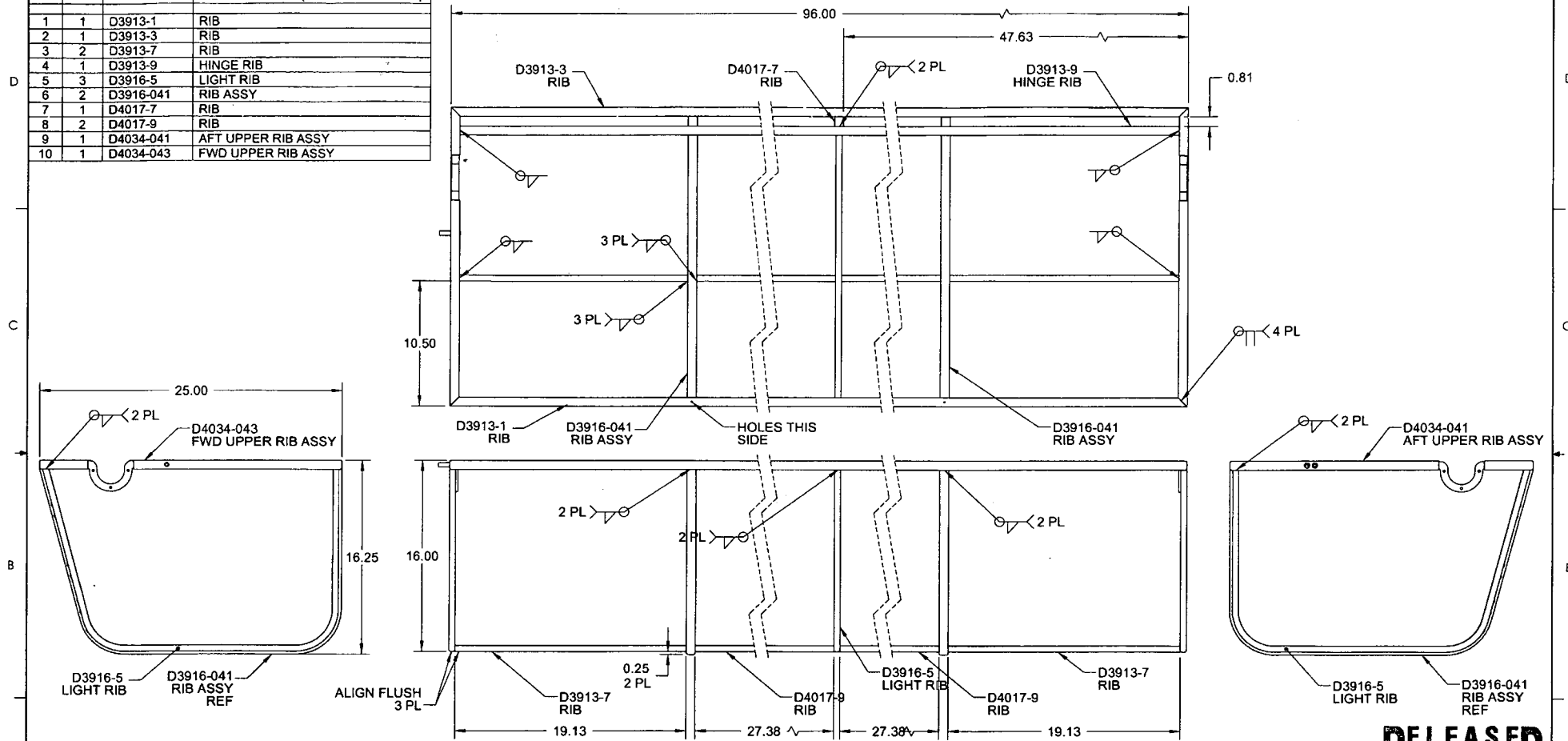
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78407

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		SHEET 4 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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2010-03-22

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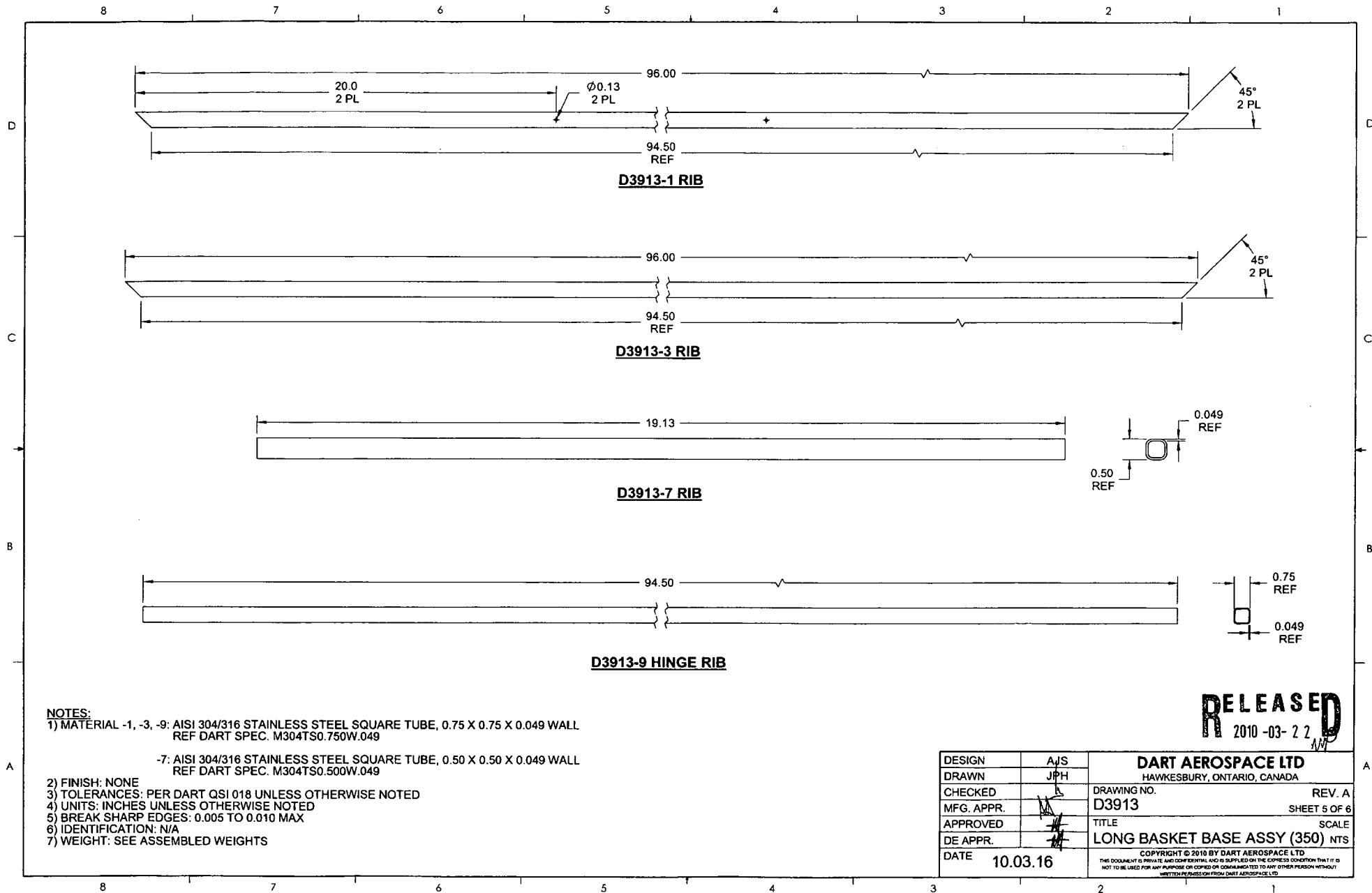
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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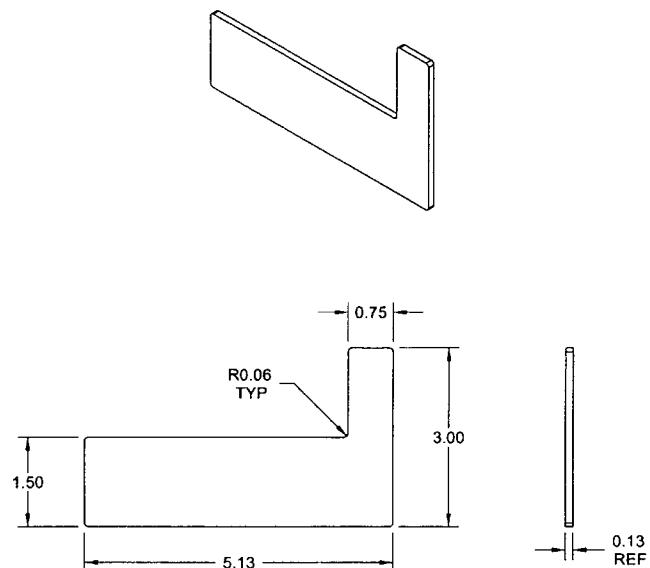
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



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
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DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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